

Work Order ID 91646 - 3

October-18-12 9:54:54 AM

\*91646\*

Page 1

Item ID: D3885-1

Revision ID:

Item Name: Standard Web

Start Date: 10/18/12 Start Qty: 10.00

Required Date: 11/02/12 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *R*

QC:

Date: 12-10-18

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Qty Reject Qty Reject Number Insp.  
Stamp

Draw Nbr

Revision Nbr

D3885

B

100

0.00

\*100\*

Purchasing

Purchasing

Memo

0.00

Purchasing

Issue P/O: 18242

Supplier: George A. Wright & Son Ltd. *Wesley*

Machine as per Dwg D3885

Conformity sheet required

*CL 12/10/24 (17)*

110

Receive & Inspect for Damage & Mat'l Certs

0.00

\*110\*

Packaging

Packaging

Memo

0.00

*(16)*

*SP-12-12*



# Work Order ID 91646

October-18-12 9:54:54 AM

**\*91646\***

Page 2

Item ID: D3885-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Standard Web

Start Date: 10/18/12 Start Qty: 10.00

**\*10\***

Required Date: 11/02/12 Req'd Qty: 10.00

**\*10\***

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Quality Control

Memo

0.00

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Hand Finishing

Memo

0.00

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Quality Control

Memo

0.00

DAS 15 12 11  
DAS 16 12 11

CF 12-12-11

① DP 12-12-11





**Work Order ID 91646**

October-18-12 9:54:54 AM

**\*91646\***

Page 3

Item ID: D3885-1

Revision ID:

Item Name: Standard Web

Start Date: 10/18/12 Start Qty: 10.00

Required Date: 11/02/12 Req'd Qty: 10.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

Identify as per dwg & Stock Location: LG

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

MF 12-12-17.

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

MF 12/12/18  
MF 12-12-17



# Picklist Print

October-18-12 9:54:53 AM

Page 1

Work Order ID: 91646  
 Parent Item: D3885-1  
 Parent Item Name: Standard Web

Start Date: 10/18/12  
 Start Qty: 10.00

Required Date: 11/02/12  
 Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130 Extrusion "I" Beam		Manufactured	No			110	Each	39.0000					

*10/21/12 14*

## Location

HALL 51826  
 LG 51826

## Loc Qty

30  
 30  
 9  
 9

## Loc Code

*14*

D3885-17

*x14*

*SP 10-10-10*

*91646*







91646

RD12-10-18

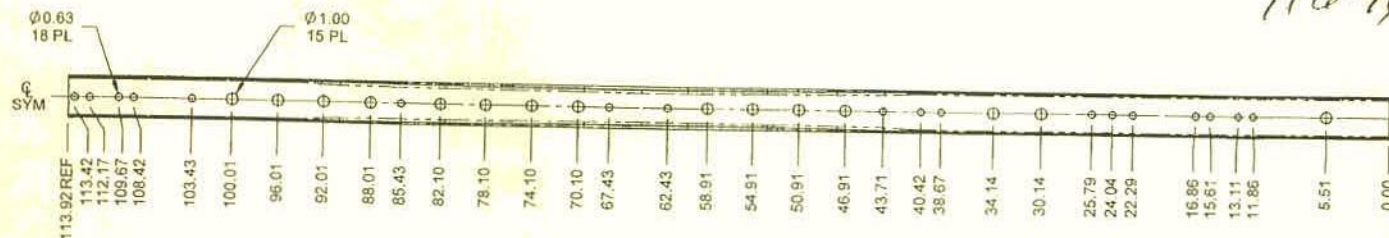
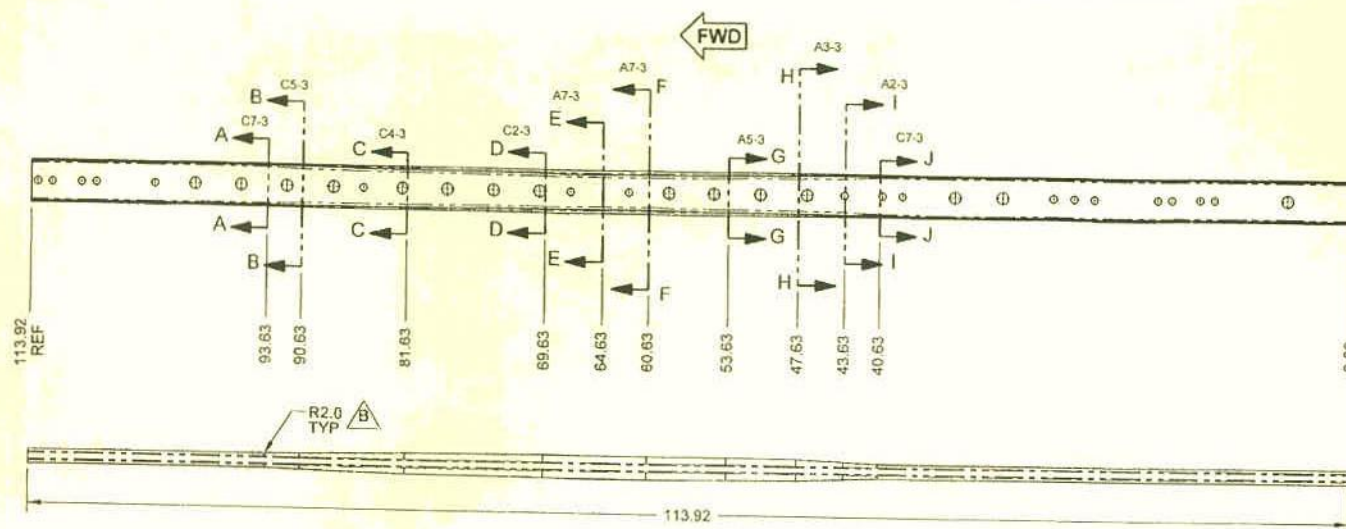
D3885-1 STANDARD WEB

D3885-3 FLOAT WEB

RELEASED  
09/05/09

B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5); ADD R2.0 TYP (ZN C8-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR		WEB	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	





# **D3885-1 STANDARD WEB**

**RELEASED**  
09/07/1980

## **D3885-1 NOTES**

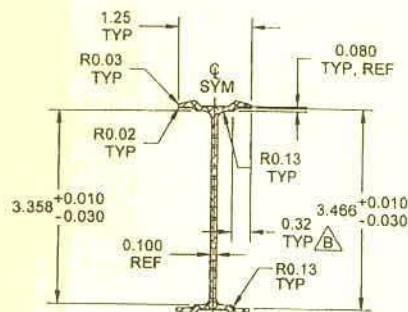
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.51 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 2 OF 3
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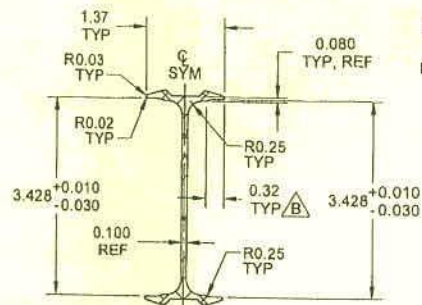




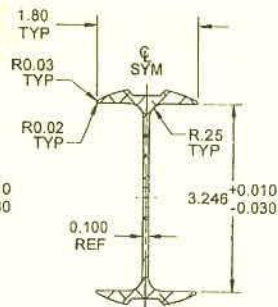




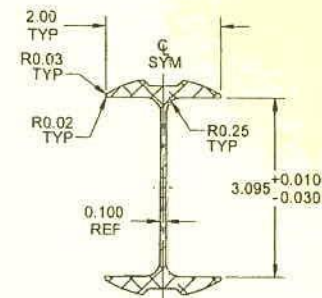
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& SECTION J-J** D6-2  
D4-2  
SCALE 5X



**SECTION B-B** D6-2  
SCALE 5X

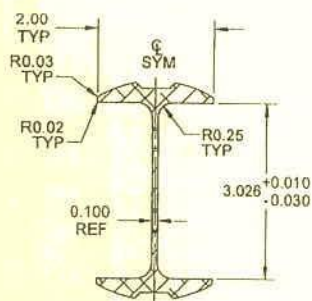


**SECTION C-C** D6-2  
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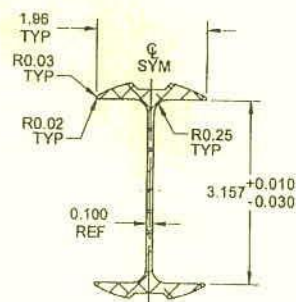


**SECTION D-D** D5-2  
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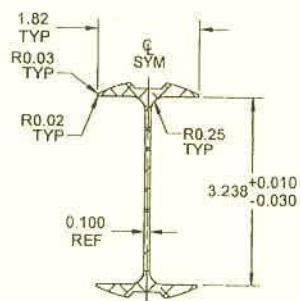
91044



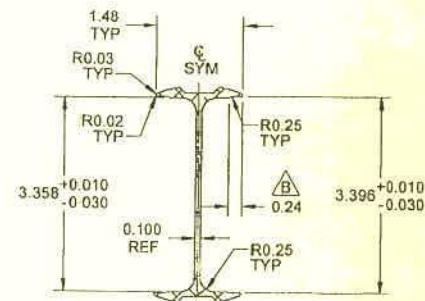
**SECTION E-E  
& SECTION F-F** D5-2  
SCALE 5X



**SECTION G-G** D4-2  
SCALE 5X




**SECTION H-H** D4-2  
SCALE 5X



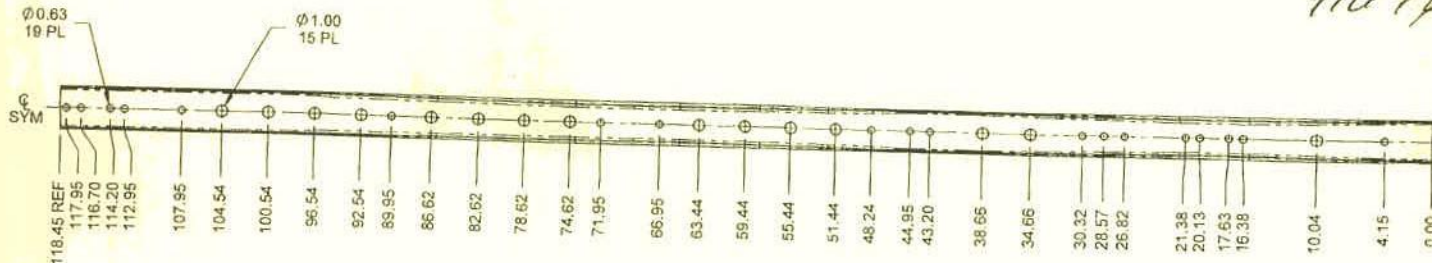
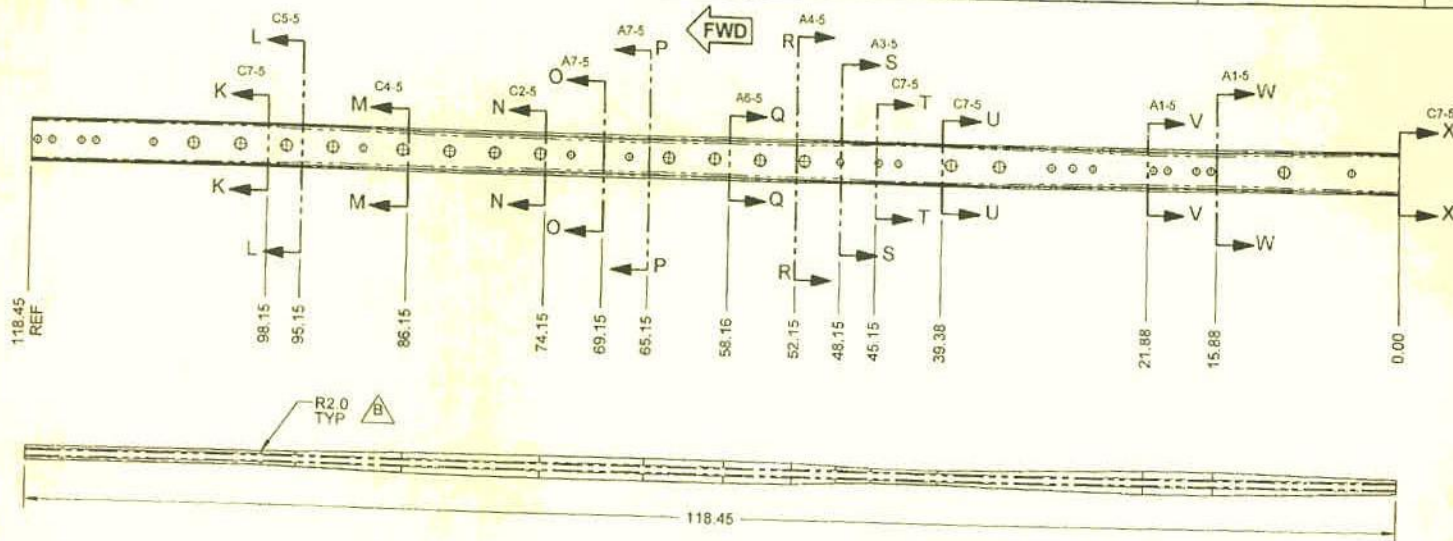
**SECTION I-I** D4-2  
SCALE 5X

**RELEASED**  
5/15/15

**D3885-1 STANDARD WEB SECTION VIEWS**

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG APPR		D3885	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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D3885-3 FLOAT WEB

D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 10.14 lbs

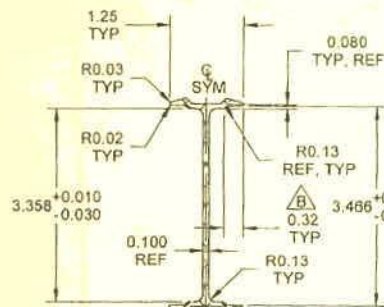
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3885	REV. B
MFG. APPR	RF	TITLE WEB	SHEET 4 OF 5
APPROVED	RF	SCALE NTS	
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DATE	09.06.30		

RELEASED  
09/07/15 AN



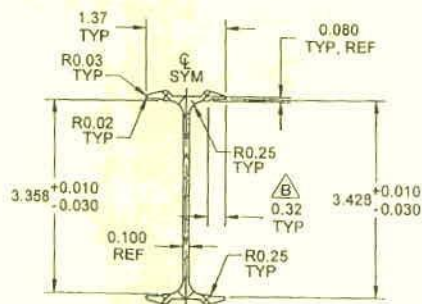




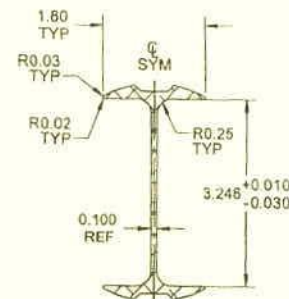


**SECTION K-K  
& SECTION T-T  
& SECTION U-U  
& SECTION X-X**  
SCALE 5X

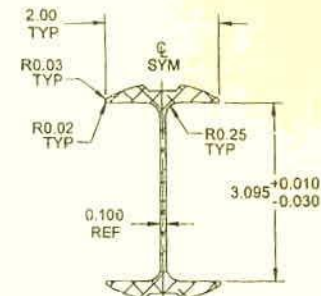
D7-4  
D4-4  
D3-4  
D1-4



**SECTION L-L** D6-4  
SCALE 5X



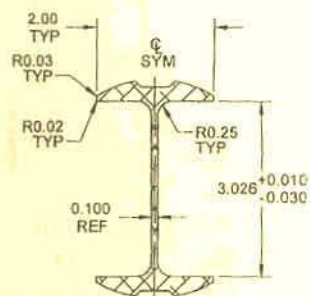
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SCALE 5X



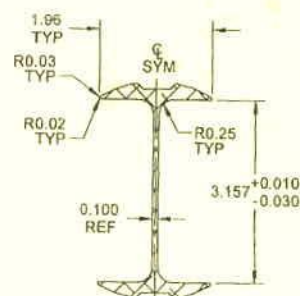
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SCALE 5X

91646

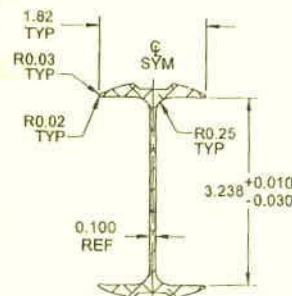
RELEASED  
9/17/15



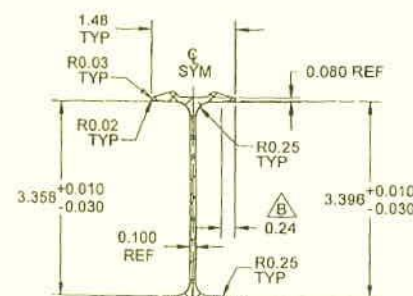
**SECTION O-O  
& SECTION P-P** D6-4  
SCALE 5X



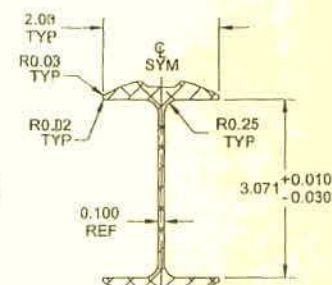
**SECTION Q-Q** D4-4  
SCALE 5X



**SECTION R-R** D4-4  
SCALE 5X



**SECTION S-S** D4-4  
SCALE 5X



**SECTION V-V  
& SECTION W-W** D3-4  
SCALE 5X

**D3885-3 FLOAT WEB SECTION VIEWS**

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV B
MFG. APPR.		D3885	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	N'S
DATE	09.06.30	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC.	

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600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662


FAX: (613) 384-2997

## CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: Dec. 7, 2012		
	P.O.# PO18242		
	WEJAY JOB# 36044		
<b>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</b>			
<b>PART NO.</b>	<b>QTY.</b>	<b>PROCESS (ES)</b>	<b>SPECIFICATION / REV</b>
D3885-1 'standard Web'	6	Machined complete per drawing req'ts.	D3885 / rev. B
Note: 1) Material supplied by Dart Aerospace. 2) 1st Article Inspection report attached.			

**Records of Inspection/Test will be retained for 5 years minimum.**

Yours truly,

  
**Clifford Smith**  
Authorized Q.A. Signatory









600 O'CONNOR DRIVE  
KINGSTON, ONTARIO  
K7P 1N3

# INSPECTION / TEST REPORT

JOB No.

36044

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO18242

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885

REV. B

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR

QUANTITY  
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Diameter .63"	18 places	+0.008/-0.001		.629 x 18		
2	Hole, Diameter 1.00"	15 places	+0.010/-0.001		.999 x 15		
3	5.51"		+/- .03		5.511		
4	11.86"		+/- .03		11.859		
5	13.11"		+/- .03		13.111		
6	15.61"		+/- .03		15.612		
7	16.86"		+/- .03		16.861		
8	22.29"		+/- .03		22.292		
9	24.04"		+/- .03		24.042		
10	25.79"		+/- .03		25.792		
11	30.14"		+/- .03		30.140		
12	34.14"		+/- .03		34.14		
13	38.67"		+/- .03		38.668		
14	40.42"		+/- .03		40.420		
15	43.71"		+/- .03		43.71		
16	46.91"		+/- .03		46.910		
17	50.91"		+/- .03		50.910		
18	54.91"		+/- .03		54.910		
19	58.91"		+/- .03		58.910		
20	62.43"		+/- .03		62.430		
21	67.43"		+/- .03		67.430		
22	70.10"		+/- .03		70.100		
23	74.10"		+/- .03		74.100		
24	78.10"		+/- .03		78.100		
25	82.10"		+/- .03		82.100		
26	85.43"		+/- .03		85.430		
27	88.01"		+/- .03		88.010		
28	92.01"		+/- .03		92.010		
29	96.01"		+/- .03		96.010		
30	100.01"		+/- .03		100.010		
31	103.43"		+/- .03		103.430		
32	108.42"		+/- .03		108.420		
33	109.67"		+/- .03		109.670		
34	112.17"		+/- .03		112.170		
35	113.42"		+/- .03		113.420		
36	113.92" REF				113.925		







600 O'CONNOR DRIVE  
KINGSTON, ONTARIO  
K7P 1N3

# INSPECTION / TEST REPORT

JOB No.

36044

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO18242

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885

REV. B

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

QUANTITY  
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
37	1.25" TYP	Section A-A-J@93.63", 40.63"	$\pm .03$		1.263		
38	R.03" TYP				✓		
39	R.02" TYP				✓		
40	3.358"		$+0.010/-0.030$		3.344 / 3.342		
41	R.13" TYP				✓		
42	.32" TYP				.320		
43	3.466"		$+0.010/-0.030$		3.438		
44	R.13" TYP				✓		
45	.080 TYP, REF				✓		
46	1.37" TYP	Section B-B@90.63"	$\pm .03$		1.379		
47	R.03" TYP				✓		
48	R.02" TYP				✓		
49	3.428"	2 places	$+0.010/-0.030$		3.399, 2		
50	R.25" TYP				✓		
51	.32" TYP				.320		
52	R.25" TYP				✓		
53	.080" TYP, REF				✓		
54	1.80" TYP	Section C-C@81.63"	$\pm .03$		1.797		
55	R.03" TYP				✓		
56	R.02" TYP				✓		
57	3.246"		$+0.010/-0.030$		3.233		
58	R.25" TYP				✓		
59	2.00" TYP	Section D-D@69.63"	$\pm .03$		1.996		
60	R.03" TYP				✓		
61	R.02" TYP				✓		
62	3.095"		$+0.010/-0.030$		3.082		
63	R.25" TYP				✓		
64	2.00" TYP	Section E-E,F-F@64.63", 60.63"	$\pm .03$		1.996		
65	R.03" TYP				✓		
66	R.02" TYP				✓		
67	3.026"		$+0.010/-0.030$		3.005 / 3.007		
68	R.25" TYP				✓		
69	1.96"	Section G-G@53.63"	$\pm .03$		1.996		
70	R.03" TYP				✓		
71	R.02" TYP				✓		
72	3.157		$+0.010/-0.030$		3.140		







600 O'CONNOR DRIVE  
KINGSTON, ONTARIO  
K7P 1N3

# INSPECTION / TEST REPORT

JOB No. 36044

PAGE: 3 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO18242

PART No. D3885-1

DWG No. D3885

DESCRIPTION: Standard Web

REV. B

MATERIAL:

Extrusions supplied by DAS

E.C.O.

INSPECTOR:

QUANTITY  
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

73	R.25" TYP	Section G-G Cont'd			✓		
74	1.82"	Section H-H@47.63"			✓		
75	R.03" TYP				1.810		
76	R.02" TYP				✓		
77	3.238"				✓		
78	R.25" TYP		+0.010/-0.030		3.222		
79	1.48"	Section I-I@43.63"			✓		
80	R.03" TYP		+/-0.03		1.476		
81	R.02" TYP				✓		
82	3.358		+0.010/-0.030		✓		
83	R.25" TYP				3.350		
84	3.396"				✓		
85	R.25" TYP		+0.010/-0.030		3.374		
86					✓		
87							
88							
89							
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